



Work Order ID 55849

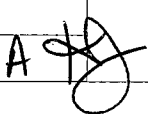
February 3, 2010 12:29:32 PM

Page 1

Item ID: D4005-11 Accept  Setup Start 
 Revision ID: Stop 
 Item Name: Angle
 Start Date: 2/03/10 Start Qty: 2.00  Cust Item ID:
 Required Date: 2/10/10 Req'd Qty: 2.00  Customer:
 Reference:

Approvals: Process Plan: 14 Date: 10-2-03 Tooling: _____ Date: _____ Run Start 
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4005	A PRELIM A 

100	Waterjet	0.00							
	FLOW CNC Waterjet	0.00							
	2024 . 032								
	Memo								
	1-Cut as per Dwg								
	Dwg Rev: <u>PRE</u>								
	Prog Rev: <u>Lim</u>								
	2-Deburr if necessary								

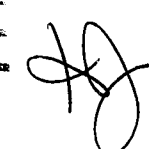
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC	0.00							
	Quality Control								


RAT NOT PULLED

HB 10-2-4



HB 10-2-4

~~PRELIMINARY ISSUE~~ 

W/O: 55849		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10.02.22	100	USE S052 H32 INSTEAD OF 2024-T3. GET ENG APPROVAL PRIOR TO SIGNING-OFF W/O - CP 10.02.22				 11.02.15 (RS) 042	

Part No: D4005-11 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55849

February 3, 2010 12:29:32 PM



Page 2

Item ID:	D4005-11	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Angle					
Start Date:	2/03/10	Start Qty: 2.00		Cust Item ID:		
Required Date:	2/10/10	Req'd Qty: 2.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00							
130 Brake NC Brake NC	Bend as per dwg Memo	0.00 0.00							
140 	QC 5 inspect work to current spec → 8/10/02/09								
150 HandFinish Hand Finishing	Chemical Conversion Coat per QS1005 4.1 Memo	0.00 0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55849

February 3, 2010 12:29:32 PM



Page 3

Item ID:	D4005-11	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Angle					
Start Date:	2/03/10	Start Qty: 2.00		Cust Item ID:		
Required Date:	2/10/10	Req'd Qty: 2.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC Inspect part completeness to step on W/O Memo	0.00 0.00				(V3)	Ø		
170 Packaging Packaging	Identify as per dwg & Stock Location: 106 Memo	0.00 0.00							
180 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

SITIVE RECALL
 AUTH
 DATE 11.03.15

★ MADE FROM SUSZ-H3Z
 INSTEAD OF 2024-T3, SEE
 W/O CHG ON SHIT

11/3/15

ME
 10-2-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4005-11 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: / Date: 11/03/16

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>55849</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/03/14	# 180	When inspecting from Pat to Rev A (Released) Dwg Forms Parts are not the same. R.C. Dwg has changed	<u>W</u> 11-03/14	Acceptable See Attached Email	<u>W</u> 11-03/14	<u>8</u> 11/03/14	<u>W</u> 11-03/14	<u>8</u> 11/03/14
		Dim 2.36" on Rev A was 2.38" on Pat so Part is 2.40" U.D.C.	<u>Pat</u> <u>email</u> <u>11/03/14</u>	Released Dwg has 2.52 as quantity with.	<u>11/03/14</u>			<u>8</u> 11/03/14

NOTE: Date & initial all entries

Picklist Print

February 3, 2010 12:29:36 PM

Page 1

Work Order ID: 55849



Parent Item: D4005-11



Parent Item Name: Angle


Start Date: 2/03/10

Required Date: 2/10/10

Comments: IPP rev A 10.01.27 New issue Prelim EC verified by:DD

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.032		Purchased		No			sf	208.5254	0.6060	1.		
												
2024-T3 .032 sheet												

12 10-2-4

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

208.5254316

102942

1.5

105555

4.0684

106272

5.3

108595

1.2

109240

6.6032

110305

88.49

110778

18.0296316

111699

11.3342

113189

69

18147

3

15031

m5052H32S.032 x1SF

15031

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

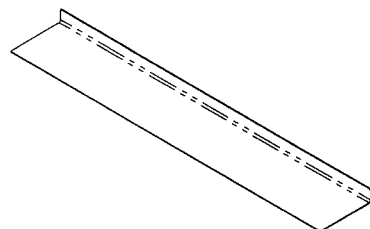
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

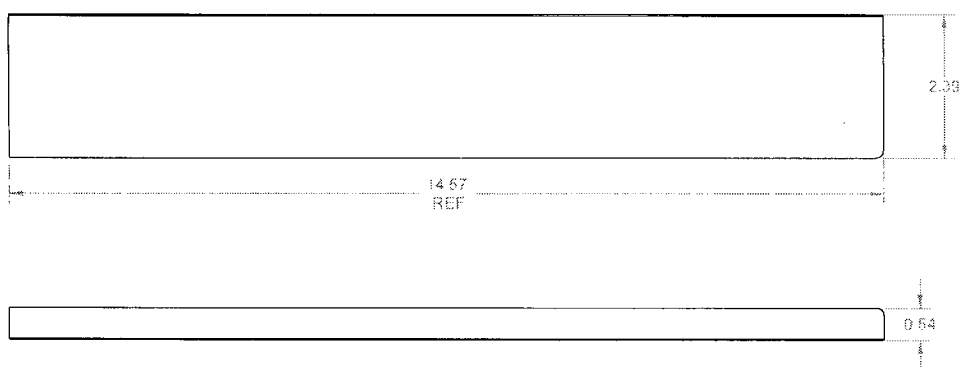
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

82



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 55849
B-10-2-03

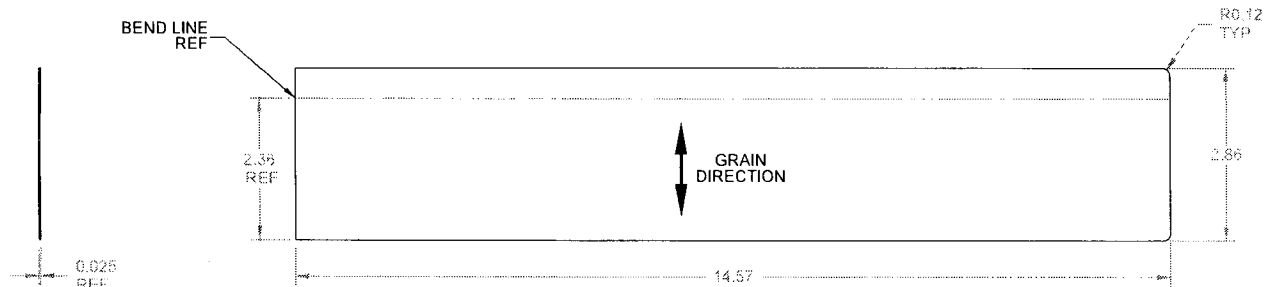


D4005-11 ANGLE

- NOTES:
- 1) MATERIAL: MADE FROM D4005-11F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4005-11" AND B/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.10 lbs

PRELIMINARY ISSUE
\$ 09.10.19

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	DRAWING NO.	REV. PA1	
MFG. APPR.	D4005	SHEET 12 OF 15	
APPROVED	TITLE	SCALE	
DE APPR.	FORWARD RESTRAINT	NTS	
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D4005-11F FLAT PATTERN

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.025 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.025
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs

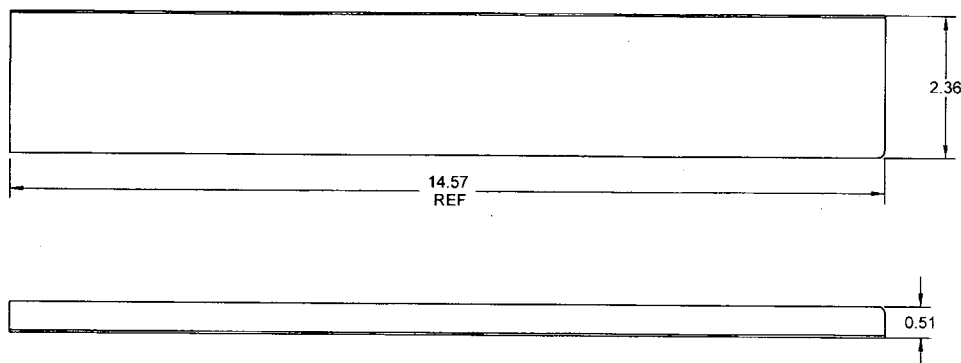
PRELIMINARY ISSUE

09.10.19

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CHECKED		DRAWING NO.	REV. PA1
MFG. APPR.		D4005	SHEET 13 OF 15
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W/0 55849

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4005-11	JCA-M47-2-12



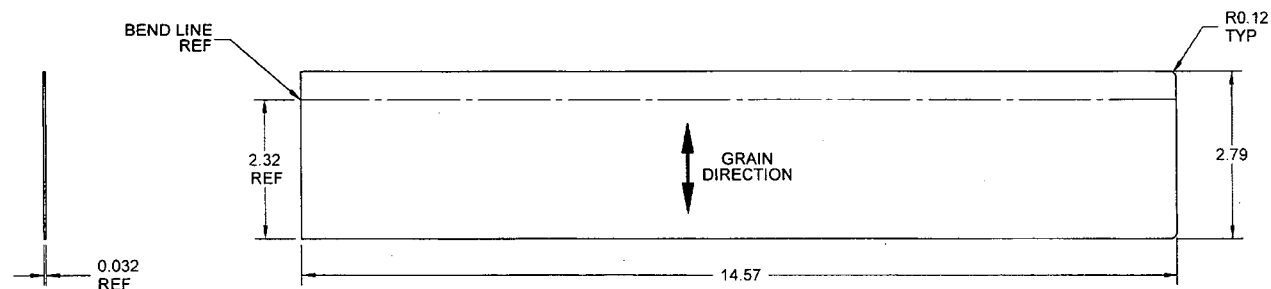
D4005-11 FINISHING STRIP

RELEASED
2010-05-05

NOTES:

- 1) MATERIAL: MADE FROM D4005-11F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4005-11" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.13 lbs

DESIGN	<i>JS</i>	DART AEROSPACE LTD	
DRAWN	<i>JS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JS</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>JS</i>	D4005	SHEET 12 OF 15
APPROVED	<i>JS</i>	TITLE	SCALE
DE APPR.	<i>JS</i>	RESTRAINT	NTS
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D4005-11F FLAT PATTERN

RELEASED
2010-05-05
MD

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.032
- OR 6061-T6/T62 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.032
- OR 5052-H32 ALUMINUM SHEET
PER QQ-A-250/8 OR AMS-QQ-A-250/8 OR AMS 4016 OR ASTM B209
REF DART SPEC M5052H32S.032

- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.13 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4005	SHEET 13 OF 15
APPROVED		TITLE	SCALE
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Linda Lacelle

From: Harvey Siemens <hsiemens@dartaero.com>
Sent: March 14, 2011 9:07 AM
To: 'Linda Lacelle'
Subject: RE: D4005-11

Yes, Linda, not a problem

Regards,

Harvey Siemens

Mechanical Designer
DART Aerospace Ltd.

P: 403-717-0328
F: 403-717-1288
E: hsiemens@dartaero.com
W: www.dartaero.com
M: 1060 McTavish Road NE, Calgary, Alberta, T2E 7G6

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From: Linda Lacelle [<mailto:llacelle@dartaero.com>]
Sent: March-14-11 6:09 AM
To: 'Harvey Siemens'
Subject: D4005-11

Hi Harv,

I have 3 x D4005-11 angle (aux tank) that were made to PA1 and have a dim of 2.40, but rev. A released drwg has a dim of 2.36, is this still acceptable?

Thank You,
Linda Lacelle
Production Manager
Dart Aerospace Ltd
Hawkesbury, ON
Phone: 613 632 9577
Fax: 613 632 1053
Cell: 613 676 1655